

Work Order ID 61970

Monday, September 13, 2010 11:15:17 AM

Page 1

Ship today

Item ID: D3536-13

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 9/13/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3536

Rev A

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

B 10-9-13

(14)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-9-13

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/09/13

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61970

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Page 2

Item ID: D3536-13

Accept



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Start Date: 9/13/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: <u>FP11</u>	0.00							
Packaging	Memo	0.00							
Packaging									
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/9/13 sf 140

10/09/13

U 10-09-13

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, September 13, 2010 11:15:17 AM

Page 1

Work Order ID: 61970

Parent Item: D3536-13

Parent Item Name: Gasket





Start Date: 9/13/2010

Required Date: 9/13/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	491.6133	0.8269	10.44505			
NEOPRENE SHEET 0.063												10-9-13	

Location

Loc Qty

Loc Code

MAT

386.3602

114691

105.9602

115500

280.4

MAT052

105.2531

114176

105.2531

115500

(14)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 61970
Description: Gasket		Part Number: D3536-13
Inspection Dwg: D3536	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.90	+/-0.030	32.90	*		T	B01
29.40	+/-0.030	29.40	*		T	
27.40	+/-0.030	27.40	*		T	
23.90	+/-0.030	23.90	*		T	
18.98	+/-0.030	18.98	*		T	
14.07	+/-0.030	14.07	*		T	
9.15	+/-0.030	9.15	*		T	
5.65	+/-0.030	5.653	X		V	B02
3.90	+/-0.030	3.90	*		V	
8.00	+/-0.030	8.00	2		T	
14.00	+/-0.030	14.00	*		T	
20.00	+/-0.030	20.00	*		T	
1.89	+/-0.030	1.881	*		V	
0.30	+/-0.030	.303	*		V	
0.30	+/-0.030	.304	*		V	
Ø0.19	+0.005/-0.001	.19	*		V	

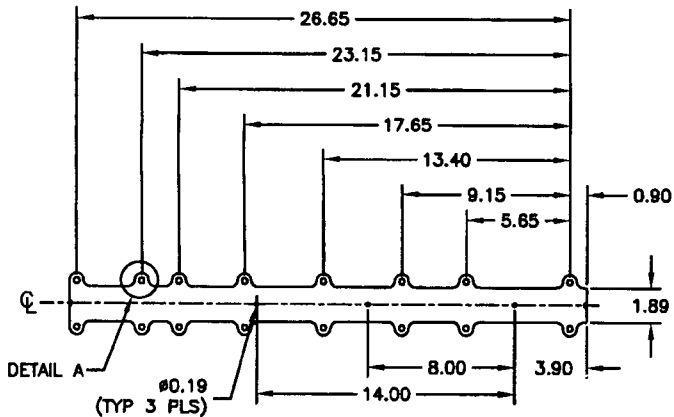
Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 10-9-13	Date: 10/02/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	BE

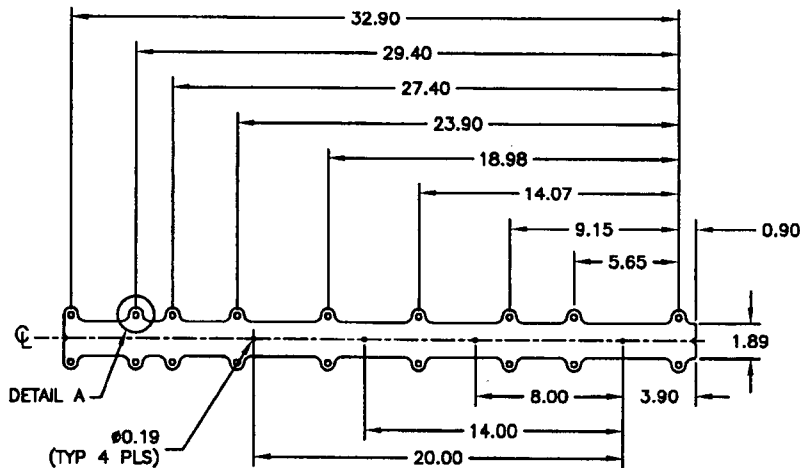
DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	CB	PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D3536	REV. A
DATE 06.10.25		TITLE GASKET	SHEET 1 OF 6
A	06.10.25	NEW ISSUE	SCALE 1:10

RELEASED
09.02.12



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

WB
6.9.70

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

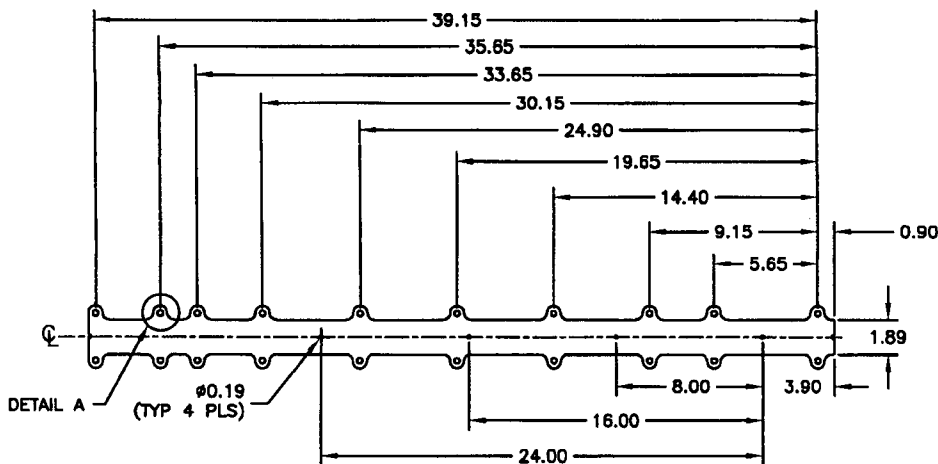
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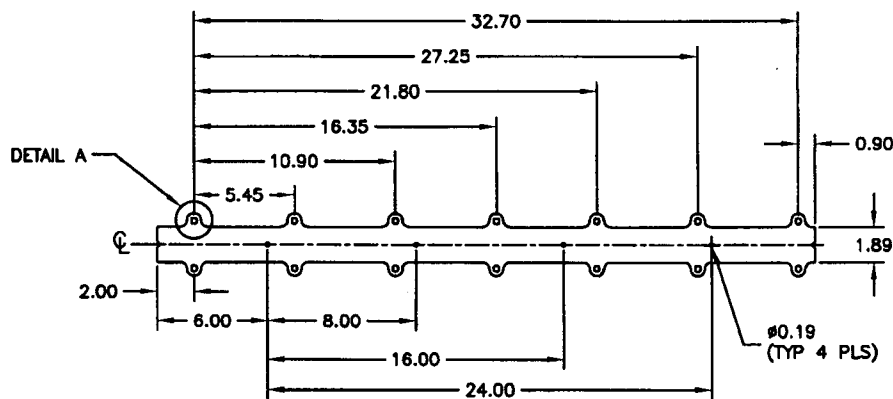
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DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 2 OF 6
				SCALE 1:10

RELEASED
07.02.12



D3536-15 GASKET



D3536-21 GASKET

61970

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
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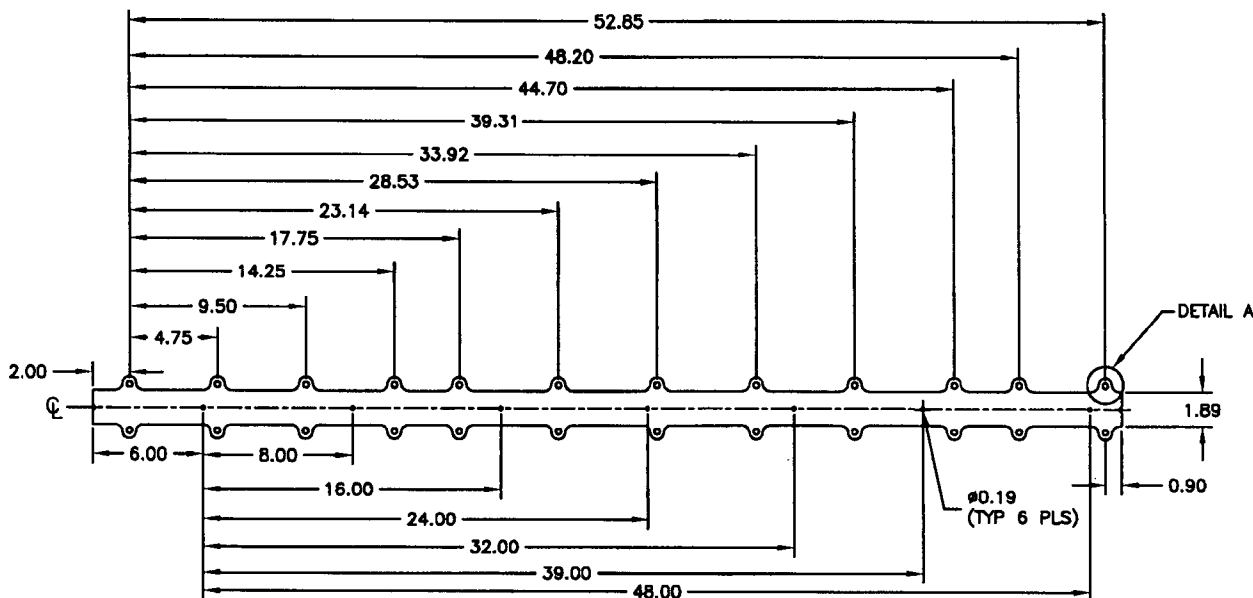
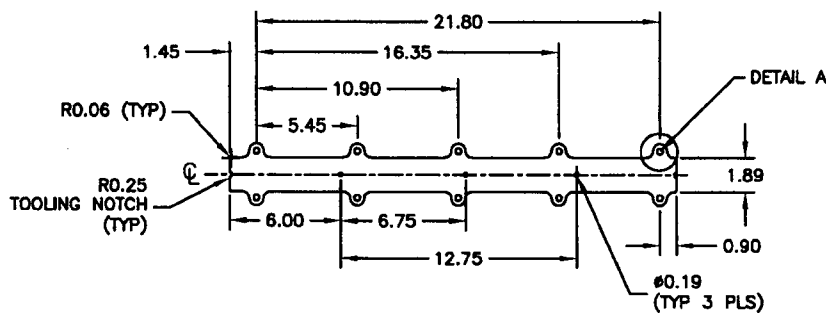
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DART

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CHECKED	AM	APPROVED	AM	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
		GASKET		SHEET 3 OF 6
				SCALE 1:10

RELEASED
070212

**D3536-23 GASKET****D3536-25 GASKET**

66970

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

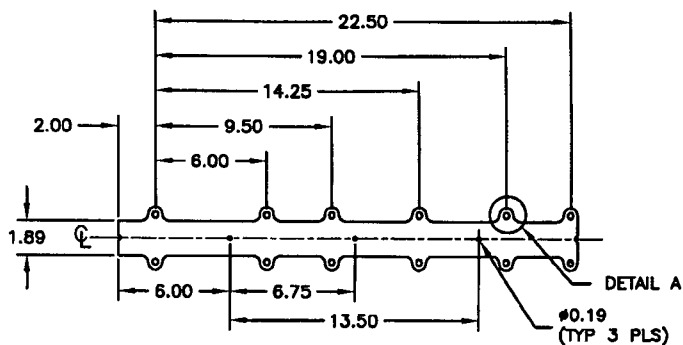
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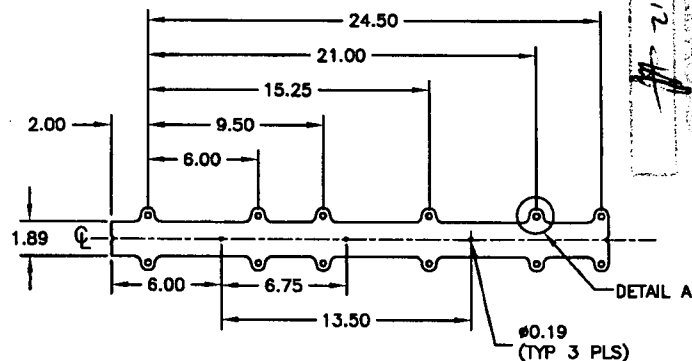
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CHECKED	AM	APPROVED	AM	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 4 OF 6
				SCALE 1:10

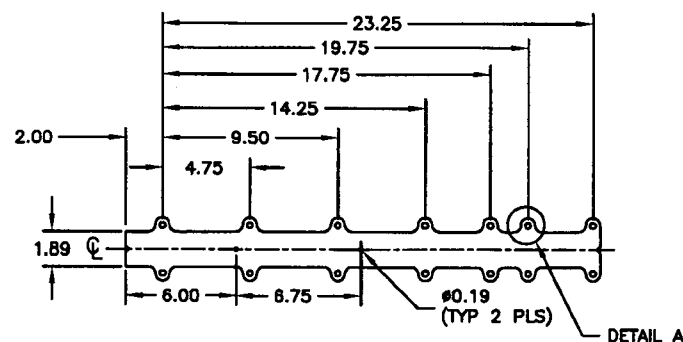
07.02.12



D3536-31 GASKET



D3536-33 GASKET



D3536-35 GASKET

61970

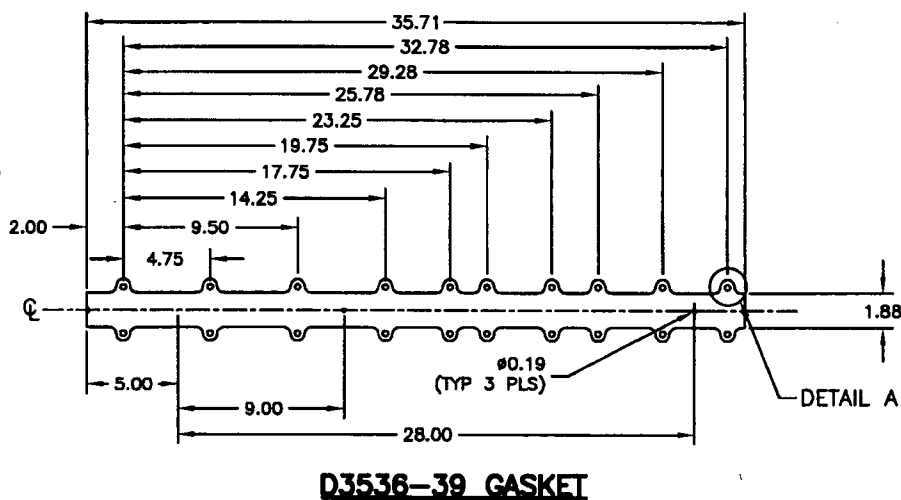
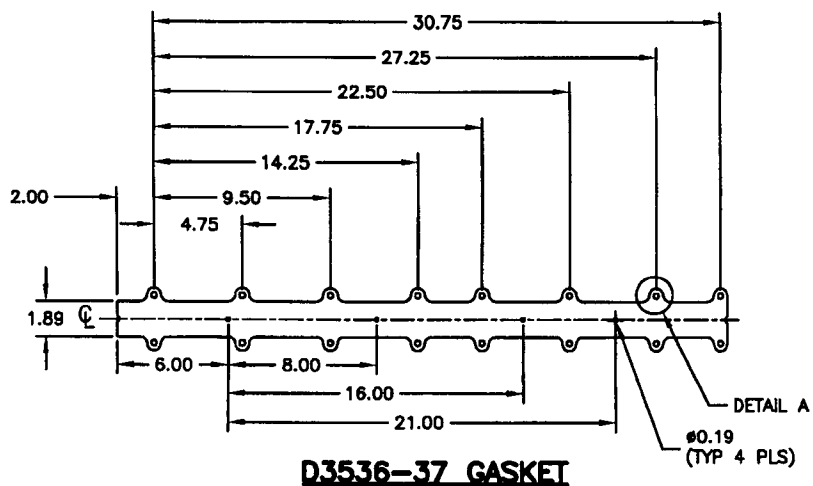
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 5 OF 6
		SCALE	1:10	

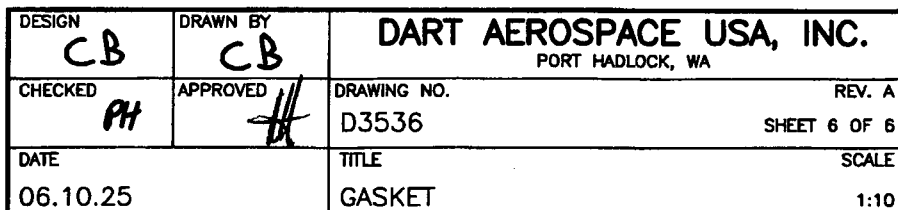
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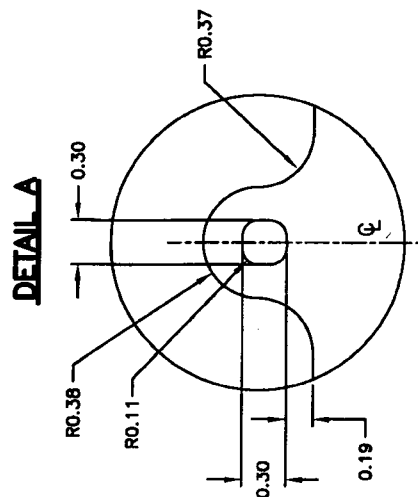
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
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61970

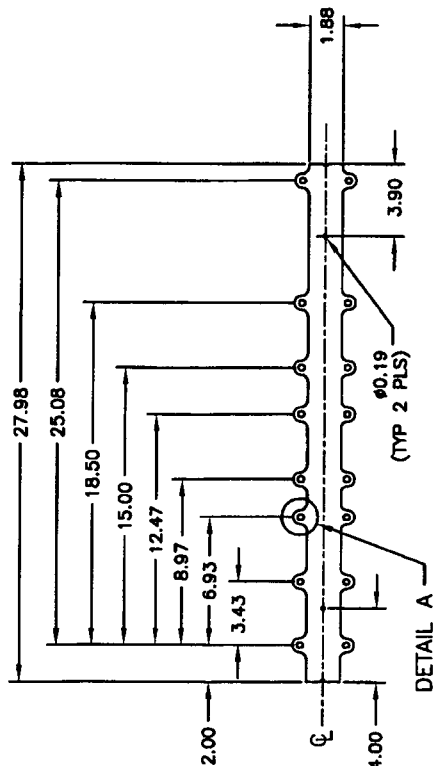


012550

07.02.12



DETAIL A



D3536-41 GASKET

2010

- (1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S-0833)
- (2) FINISH: NONE
- (3) PART IS SYMMETRICAL ABOUT C
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